

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025663**Date Inspected:** 09-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG				

**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

**Segment 13 West Trial Assembly area**

Caltrans and ZPMC have agreed to conduct visual and magnetic particle inspections (MT) of segment 13East welds as part of a special inspection program, reference NWIT number 9689. This QA Inspector observed ZPMC Inspectors used MT yoke #7455 and they completed and accepted MT inspections of segment 13BW welds: SEG3014L-057, 058, 061, 062, 063, 064, 067, 068, 069, 070, 073, 074, 075, 076, 079, 080, 081, 082, 085, 086, 087, 088, 091, 092, 093, 094, 097 and 098. This QA Inspector performed random visual and magnetic particle inspection of welds: SEG3014L-057, 058, 061, 062, 063, 064, 067, 068, 087, 091, 093, 097 and 098 and these welds appear to comply with AWS D1.5 MT and visual requirements. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report.

**Segment 13East Trial Assembly area**

ZPMC requested Caltrans personnel to perform visual inspections of OBG segment 13W cross beam side interior surface upper edges of side plates SP3079, SP3080 and SP3081 between panel points PP121 and PP124.3 following the initial pre-blast cleaning of the steel surfaces. This QA Inspector along with three other QA

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

Inspectors performed random visual inspections of these areas and observed multiple areas that require grinding to remove arc strikes, sharp edges, minor gouges, temporary welds and two areas that require weld repairs. The locations where weld repairs are needed appear to be where ZPMC gouged the base material to a depth of approximately 2mm when they removed temporary alignment plates. This QA Inspector issued a “Blast Incident Report” to document the locations of these weld repairs. See the photographs below for additional information.



### Summary of Conversations:

See Above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

---